

**Work Order ID 85538**

June-11-12 9:53:30 AM

*Ship 28/06*  
**\*85538\****Right*

Page 1

Item ID: D119-646-243

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*Date: *12/06/11*

Tooling:

Date:

Run Start **\*NR1\***QC: ☒

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3905	B								
D3905-045,-13	B								
IIN-D119-646	B								
100		0.00							
<b>*100*</b>									
DC									
Document Control	Memo	0.00							
	Photocopy bluefile & type labels per PPP D119-646-243								
	CHG 001								
110		0.00							
<b>*110*</b>									
Skidtubes									
Skidtubes	Memo	0.00							
	1- Inspect Mat'l D2500-1-190 for damage								
	2- Ensure squareness of ends								

*De 12/06/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85538

**\*85538\***

Page 2

June-11-12 9:53:30 AM

Item ID: D119-646-243

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*120*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
150		0.00							
<b>*150*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill								
	2- Scribe batch # inside aft end of tube								

7/6 12-6-12

① 12/06/13  
BE

DC 12/06/13



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85538

**\*85538\***

Page 3

June-11-12 9:53:30 AM

Item ID: D119-646-243

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Float Skidtube w/ Training Wearplates

Stop **\*NS2\***

Start Date: 08/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155		0.00							

**\*155\***

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end.

2- Ensure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

DC 12/06/14

165

**\*165\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DP 12-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85538****\*85538\***

Page 4

June-11-12 9:53:30 AM

Item ID: D119-646-243

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

0.00

**\*180\***

Skidtubes

Skidtubes

Memo

0.00

1- Veriffy dimention of bend as per dwg D3905

2- Buff out marks left from bending.

3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F, open to finished size

4- Drill Aft wearplate and wearpad holes using DT9546 and DT9545 as per dwg D3905 detail G open to finished size

5- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E)  
\*\*\*DO NOT OPEN FWD SADDLE HOLES\*\*\*

6- Deburr, blow out chips from inside of tube

7-Bond web in place as per Dwg D3905 &amp; QSI 015.

A/RSikaflex-291 12/469Sikaflex expire date: 13-4-12Start: 12/06/18Time: 11:26Finish: 12-06-20Time: 9:00

\*\*\*\*\* (Adhere for 12 hours) \*\*\*\*\*

De 12/06/18

- De 12/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 85538

**\*85538\***

Page 5

June-11-12 9:53:30 AM

Item ID: D119-646-243

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									
200		0.00							
<b>*200*</b>									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1- Bend Fwd end of tube using bender 1 and bend prog. D3905 Fwd.Use bending aid DT9544 ensure proper positioning  2- Cut Fwd end of tube as per dwg. ***VERIFY MEASUREMENT BEFORE CUTTING***								

DD 12-6-19

> DC 12/06/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85538

**\*85538\***

Page 6

June-11-12 9:53:30 AM

Item ID: D119-646-243

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210		0.00							
<b>*210*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1- Buff out marks left from bending								
	2- Drill Fwd cap holes using DT8215. Open Fwd and Aft cap holes to 0.208"								
	3- Open Fwd saddle holes to finished size as per dwg								
	4- Drill Fwd x-bolt hole and open to finished size. (Holes must be laid out manually)								
	5- Drill towing hole and open to finished size. (Holes must be laid out manually)								
	6- Open Aft float holes 0.391" as per dwg D3905 detail G and section F-F								
	7- Deburr, blow out chips from inside of tube.								
220	QC5- Inspect part completeness to step on W/O	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									

*Handwritten signature and date: 12-6-20*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85538

June-11-12 9:53:30 AM

**\*85538\***

Page 7

Item ID: D119-646-243

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Float Skidtube w/ Training Wearplates

Stop **\*NS2\***

Start Date: 08/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

224

0.00

**\*224\***

Skidtubes

Skidtubes

Memo

0.00

1- Countersink x-bolt holes as per dwg

2- Remove alodine prepare for welding

3- Insert x-bolt spacers

4- Weld x-bolt spacer as per dwg  
A/R Alum rod Batch: m/20164

5- Grind welds flush as per dwg

6- Counter bore x-bolt holes as per dwg

7- Deburr

*BE 12/06/20*  
*BE 12/06/20*  
*BE 12/06/21*

225

QC5- Inspect part completeness to step on W/O

0.00

**\*225\***

QC

Memo

0.00

Quality Control

*1* *m/12/06/21*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*85538\***

Page 8

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 08/06/2012   **Start Qty:** 1.00   **\*1\***

**Cust Item ID:**

**Required Date:** 22/06/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

[illegible]

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**\*85538\***

Page 9

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 08/06/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 22/06/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**    **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run** **Start** **\*NR1\***  
                  **QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Stop** **\*NR2\***

[illegible]

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85538

**\*85538\***

Page 10

June-11-12 9:53:30 AM

Item ID: D119-646-243

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Float Skidtube w/ Training Wearplates

Stop **\*NS2\***

Start Date: 08/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00

**\*270\***

HandFinish

Hand Finishing

Memo

0.00

1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers

A/RSikaflex-240/-291 12/409

Sikaflex expire date: 13/07

2- install plugs assembly as per dwg.

3 -Inspect for foreign objects as per QSI 024

4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-240/-291 12/409

Sikaflex expire date: 13/07

144 ~~8~~ SP 12/06/29.

280

QC5- Inspect part completeness to step on W/O 0.00

**\*280\***

QC

Quality Control

Memo

0.00

8/17/09/29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85538

**\*85538\***

Page 11

June-11-12 9:53:30 AM

Item ID: D119-646-243

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Float Skidtube w/ Training Wearplates

Stop **\*NS2\***

Start Date: 08/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
285	Wing Walk as per dwg QSI005 4.4 Batch <u>121613</u>	0.00							
<b>*285*</b>									
HandFinish	Memo	0.00				1	2	(28)	12/06/29
Hand Finishing									
286	QC3- Inspect Part Finish	0.00							
<b>*286*</b>									
QC	Memo	0.00							12/06/29
Quality Control									
290	Identify as per dwg & Stock Location: _____	0.00							
<b>*290*</b>									
Packaging	Memo	0.00							12/06/29
Packaging									

*PP 85538*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85538

\*85538\*

Page 12

June-11-12 9:53:30 AM

Item ID: D119-646-243

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

300 QC21- Final Inspection - Work Order Release

0.00

\*300\*

QC Memo

0.00

Quality Control

MLJ 12/06/29

MLJ 12/08/29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June-11-12 9:53:33 AM

Page 1

7

Work Order ID: 85538

**\*85538\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2500-1-190

Manufactured No

110

Each

85.0000

1

1

**\*D2500-1-190\***

Ext'n -1" Beam Tube 4"

\*\*

DC 12/06/12

Location

Loc Qty

Loc Code

HALL

85

74777

12

80061

73

D3885-3

Manufactured No

170

Each

10.0000

1

1

**\*D3885-3\***

Standard Web

\*\*

DC 12/06/18

Location

Loc Qty

Loc Code

LG

10

52425

10

D3903-1

Manufactured No

190

Each

70.0000

12

12

**\*D3903-1\***

Spacer

\*\*

BE 2/06/20

Location

Loc Qty

Loc Code

LG

40

74876

40

LG001

30

78790

30

12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-11-12 9:53:33 AM

Page 2

Work Order ID: 85538

**\*85538\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3681-1

Manufactured No

190

Each

53.0000

8

8

**\*D3681-1\***

Spacer

\*\*

BE 12/06/20

Location

Loc Qty

Loc Code

LG

43

80361

1

84053

42

8

LG001

10

68958

2

69893

2

71845

2

74874

1

76004

1

77501

2

D3683-3

Purchased

No

250

Each

586.0000

12

12

**\*D3683-3\***

Insert

\*\*

12

2P

12/06/26

Location

Loc Qty

Loc Code

FP002

26

47805

26

ST060

560

47805 ✓

560

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-11-12 9:53:33 AM

Page 3

Work Order ID: 85538

**\*85538\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

1,973.000

10

10

**\*AI S4-1032-130\***

Insert

\*\*

10

②P 12/06/26

## Location

## Loc Qty

## Loc Code

ST280

205

119084

116

120671

89

ST281

44

120807

36

120837

8

ST282

1724

121269 ✓

1724

D2855-3

Manufactured

No

270

Each

22.0000

2

2

**\*D2855-3\***

Cap

\*\*

2

②P 12/06/26

## Location

## Loc Qty

## Loc Code

FP002

22

52281 ✓

7

75080

15

D3672-1

Manufactured

No

270

Each

1,530.000

4

4

**\*D3672-1\***

Phenolic Washer

\*\*

4

②P 12/06/26

## Location

## Loc Qty

## Loc Code

ST060

1530

72229

4

76277

20

80369 ✓

496

83608

500

85222

510

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-11-12 9:53:33 AM

Page 4

Work Order ID: 85538

**\*85538\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3846-I	Manufactured	No	270	Each	36.0000	1	1	
<b>*D3846-1*</b>						**	1	(DP) 12/06/26
GASKET								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP002	36				
			51827	4				
			53735 ✓	32				
D3846-11	Manufactured	No	270	Each	13.0000	1	1	
<b>*D3846-11*</b>						**	1	(DP) 12/06/26
GASKET								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP002	13				
			51833 ✓	13				
D3847-I	Manufactured	No	270	Each	11.0000	1	1	
<b>*D3847-1*</b>						**	1	(DP) 12/06/26
WEARPAD								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP002	11				
			51824 ✓	11				
D3847-11	Manufactured	No	270	Each	15.0000	1	1	
<b>*D3847-11*</b>						**	1	(DP) 12/06/26
WEARPAD								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP002	15				
			51824	15				
D3849-047	Manufactured	No	270	Each	0.0000	1	1	
<b>*D3849-047*</b>						**	1	(DP) 12/06/29
WEARPLATE								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP002	15				
			51824	15				
			85543 ✓					

June-11-12 9:53:34 AM

Shop Packet Print

Page 4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June-11-12 9:53:34 AM

Page 5

Work Order ID: 85538

**\*85538\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3849-045

Manufactured No

270

Each

0.0000

1

1

**\*D3849-045\***

AFT WEARPLATE ASSY, FLOAT GEAR

D3904-1

Manufactured No

270

Each

177.0000

16

16

**\*D3904-1\***

Washer

85542✓

\*\*

1

2P

12/06/27

\*\*

16

2P

12/06/26

Location

Loc Qty

Loc Code

ST068

177

51875✓

177

D3672-3

Manufactured No

270

Each

583.0000

12

12

**\*D3672-3\***

Phenolic Washer

\*\*

12

2P

12/06/26

Location

Loc Qty

Loc Code

ST060

583

84361✓

583

AN3C5A

Purchased No

270

Each

1,274.000

14

14

**\*AN3C5A\***

Bolt

\*\*

14

2P

12/06/26

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1267

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255

500

121444✓

154

121708

500

June-11-12 9:53:34 AM

Shop Packet Print

Page 5

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-11-12 9:53:34 AM

Page 6

Work Order ID: 85538

**\*85538\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C46A	Purchased	No	270	Each	43.0000	4	4
<b>*AN3C46A*</b>						**	4 (2P) 12/06/26
BOLT							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
AN960C10L	<del>✗</del> NAS1149C0332 ✓	Purchased	ST355	43			
	R	No	120447 ✓	43			
<b>*AN960C10I *</b>						**	10 14 (2P) 12/06/26
washer			122063 ✓				

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
AN960C416	<del>✗</del> NAS1149C0463 ✓	Purchased	ST	21			
	R	No	107534	21			
<b>*AN960C416*</b>						**	12 (2P) 12/06/26
washer			119097 ✓				

MS21043-3	Purchased	No	270	Each	1,439.000	8	8
<b>*MS21043-3*</b>						**	8 (2P) 12/06/26
Nut							

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG		72	
	103691	72	
ST301		1367	
	118077	2	
	118614 ✓	51	
	118686	30	
	119758	20	
	121255	270	
	121708	994	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-11-12 9:53:34 AM

Page 7

Work Order ID: 85538

**\*85538\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039C4-08

Purchased

No

270

Each

98.0000

12

12

**\*MS27039C4-08\***

SCREW

\*\*

12

24

12/06/26

Location

Loc Qty

Loc Code

FP002

7

17831 ✓

7

3

ST293

91

114721 ✓

91

9

AN3C50A

Purchased

No

270

Each

78.0000

4

4

**\*AN3C50A\***

Bolt

\*\*

4

24

12/06/26

Location

Loc Qty

Loc Code

ST355

78

112761

20

114442 ✓

33

120447

25

D3411-3

Manufactured

No

270

Each

58.0000

16

16

**\*D3411-3\***

WASHER

\*\*

16

24

12/06/26

Location

Loc Qty

Loc Code

ST042

58

51635

17

55317

41

# Dart Aerospace Ltd

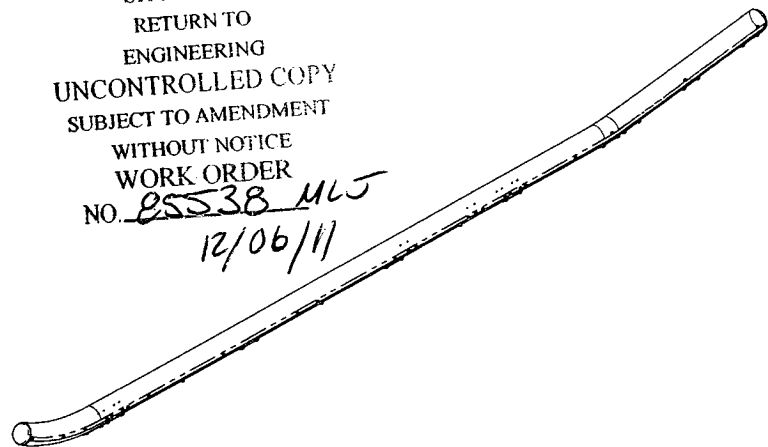
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25538 MLJ  
12/06/11



**D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)**  
**D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)**  
**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs  
D3905-043 = 47.0 lbs  
D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES  
ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT  
PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT  
PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE  
WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS.  
INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS  
WITH SIKAFLEX-241/-291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	5	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	46	46	14	AN3C5A	BOLT
43			4	AN3C46A	BOLT
44			4	AN3C50A	BOLT
45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW

RELEASED  
12/15/11

REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A6-5, A5-6, C5-7, C3-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C1-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A8-7 & D7-8); REVISED NOTE N (ZN A8-7)		RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 1 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

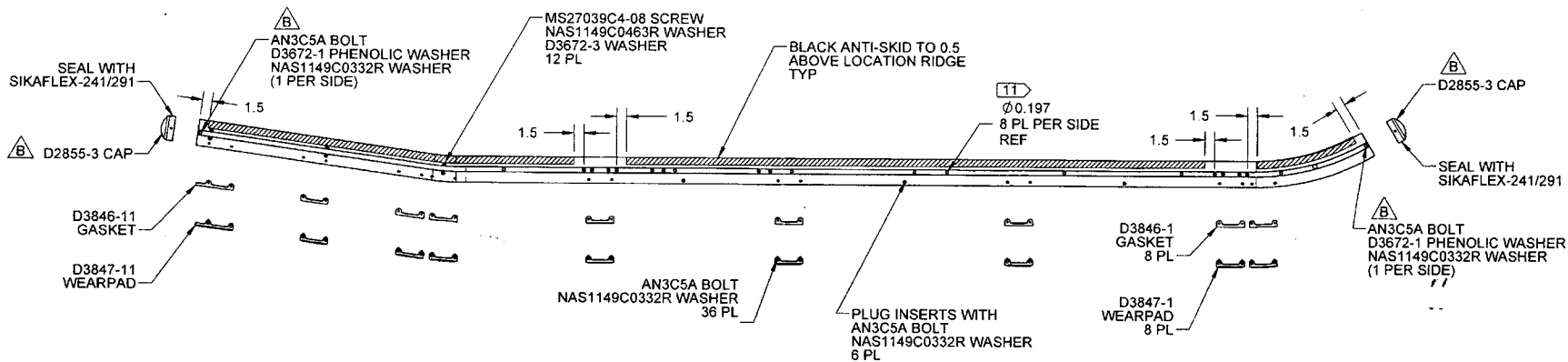
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



05538



**D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD**  
(MAKE FROM D3905-11 SKIDTUBE)

RELEASED  
07/01/15

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 2 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	<small>           COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.            THIS DOCUMENT IS TRANSMITTED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.         </small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

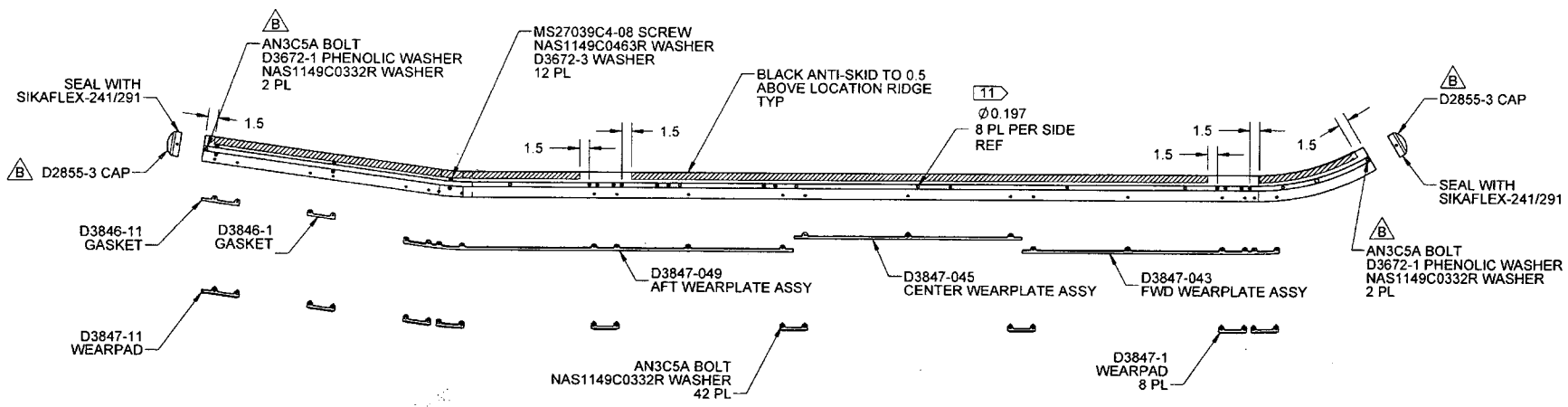
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

2538



**D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE**  
(MAKE FROM D3905-11 SKIDTUBE)

RELEASED  
09/07/15

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3905	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

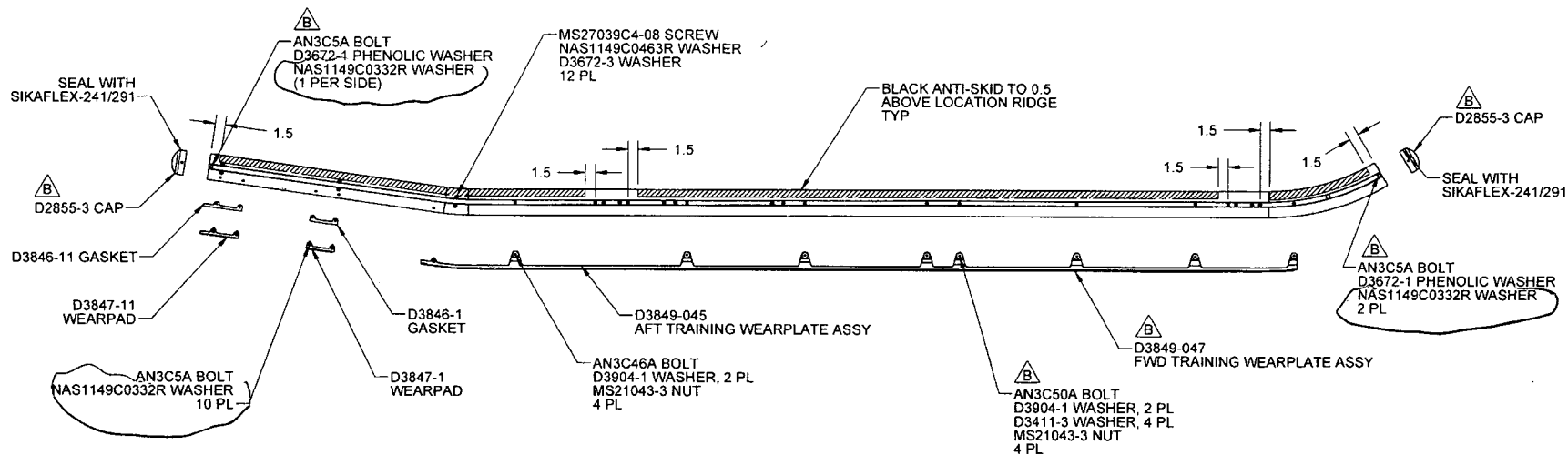
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




**NOTE:** Date & initial all entries

25539



**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE**  
(MAKE FROM D3905-13 SKIDTUBE)

RELEASED  
09/07/15 MAB

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3905	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

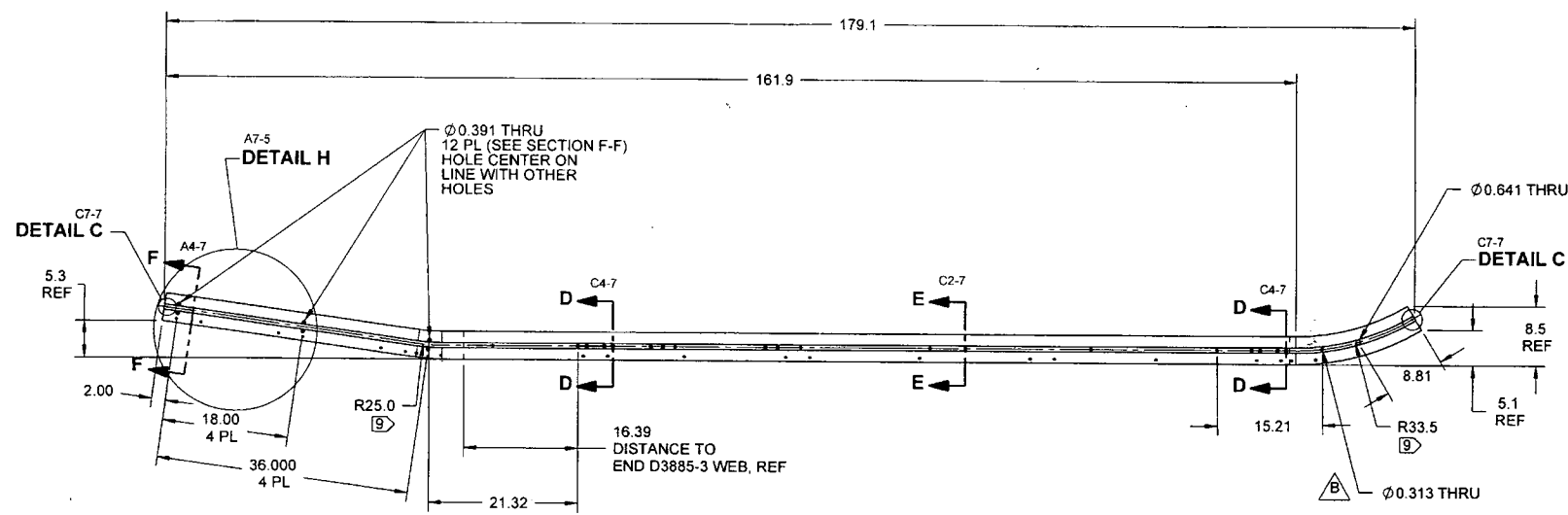
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

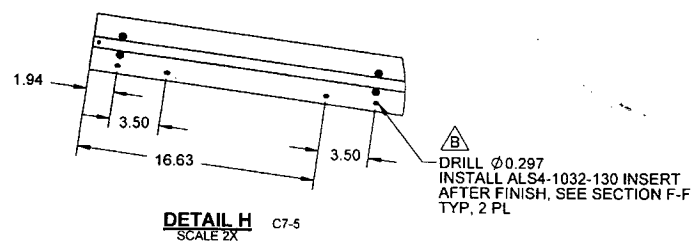
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

95538



**D3905-11 FLOAT SKIDTUBE**  
(MAKE FROM D3905-1 TUBE)



**RELEASED**  
9/15/10

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>
DRAWN	RF	PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3905</b> REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE <b>A119 FLOAT SKIDTUBE ASSY</b> SCALE
DE APPR.	<i>[Signature]</i>	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

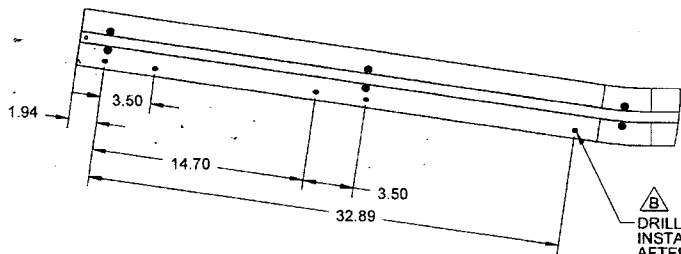
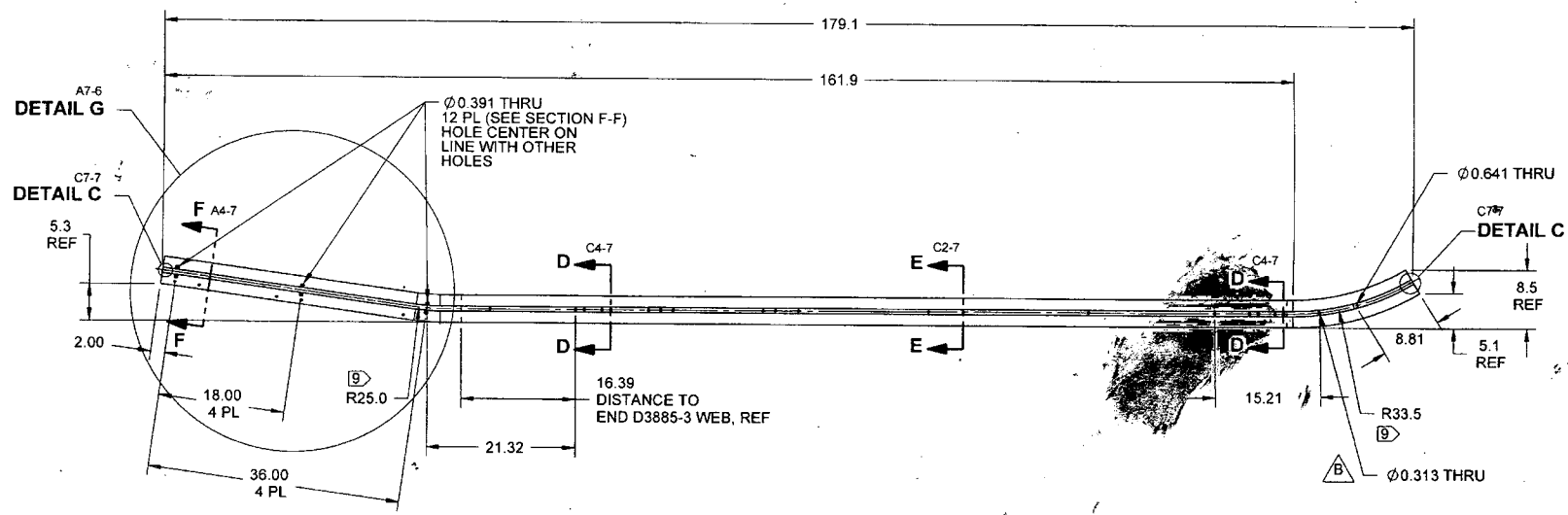
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



25538



**D3905-13 FLOAT SKIDTUBE**  
(MAKE FROM D3905-1 TUBE)

**B**  
DRILL Ø0.297  
INSTALL ALS4-1032-130 INSERT  
AFTER FINISH. SEE SECTION F-F  
TYP, 2 PL

**RELEASED**  
9/6/13

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 6 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR GIVEN OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

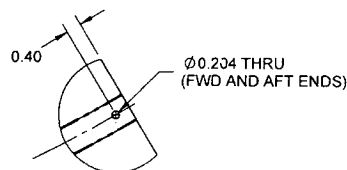
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

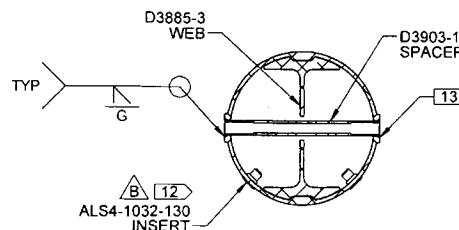
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

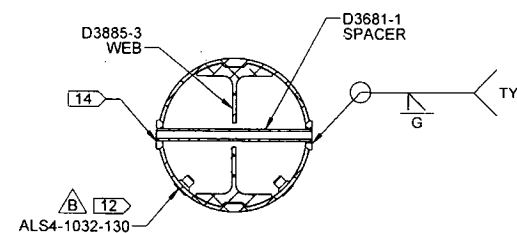
**NOTE:** Date & initial all entries



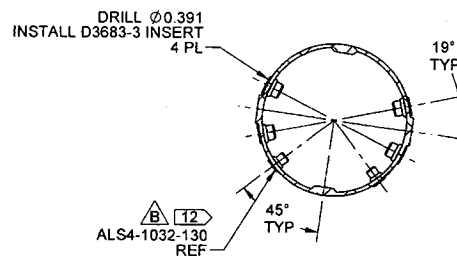
**DETAIL C**  
SCALE 4X  
C1-5  
C8-5  
C8-6  
C1-6



**SECTION D-D**  
SCALE 4X  
(FOR 12 x  $\phi 0.375$  HOLES  
PER SKIDTUBE)  
C5-5  
C2-5  
C5-6  
C2-6



**SECTION E-E**  
SCALE 4X  
(FOR 8 x  $\phi 0.313$  HOLES  
PER SKIDTUBE)  
C4-5  
C4-6



**SECTION F-F**  
SCALE 4X  
C7-6  
C7-5

**NOTES:**

- 13) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR  $\phi 0.375$  HOLES ONLY:  
i) CHAMFER HOLES  $\phi 0.475 \times 45^\circ$  (BOTH SIDES)  
ii) INSERT D3903-1 SPACER  
iii) WELD INTO PLACE AND GRIND FLUSH  
iv) C'BORE TO  $0.313 \times 0.75$  DEEP  
v) DEBURR HOLES

- 14) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR  $\phi 0.313$  HOLES ONLY:  
vi) CHAMFER HOLES  $\phi 0.354 \times 45^\circ$  OR  $0.050$  DEEP  $\times 45^\circ$  (BOTH SIDES)  
vii) INSERT D3681-1 SPACER  
viii) WELD INTO PLACE AND GRIND FLUSH  
ix) DEBURR HOLES

RELEASED  
10/17/15

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO. D3905	REV. B
MFG. APPR.	RF		SHEET 7 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

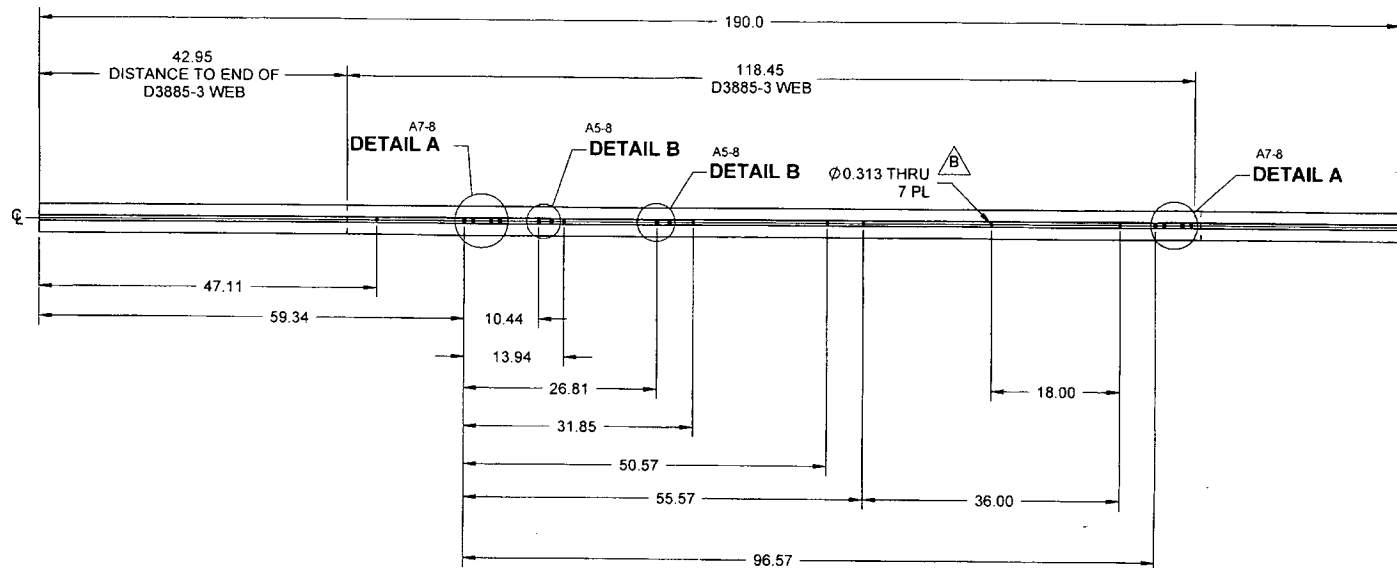
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

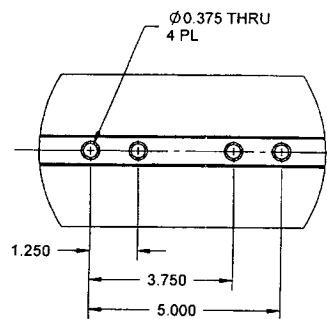
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

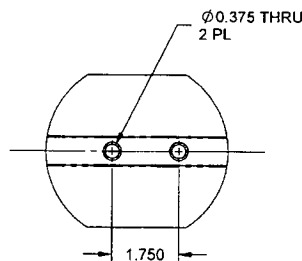
25538



**D3905-1 TUBE**  
(MAKE FROM D2500-1-190 EXTRUSION)



**DETAIL A** D6-8  
SCALE 4X D2-8



**DETAIL B** D5-8  
SCALE 4X D4-8

RELEASED  
09/07/15

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3905	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries